

Date: Thursday, 5/4/2006 10:46:24 AM  
 User: Kim Johnston

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : SADDLE FITTING, FWD (OUTBOARD/INBOARD)  
 Job Number : 26973  
 Estimate Number : 10531  
 P.O. Number : N/A Part Number : D2572  
 This Issue : 5/4/2006 S.O. No. : N/A Drawing Number : D2572 REV E  
 Prsht Rev. : NC Project Number : N/A  
 First Issue : N/A Type : MACHINED PARTS Drawing Revision : E  
 Previous Run : 26512 Material : N/A  
 Due Date : 5/25/2006 Qty: 12 Um: Each  
 Written By : See A Comment Below  
 Checked & Approved By : 06/05/04  
 Comment : Est: 1 02.10.02 Re-format; Change to Dwg Rev. D & incorporated D2572KJ

## Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 D6101005 7075-T7351 8.25X5.0X2.5



Comment: Qty.: 1.0000 Each(s)/Unit Total : 12.0000 Each(s)

7075-T7351 8.25X5.0X2.5

Make from D6101-005 billet for D2572

Ensure that grain is along 5.00" length

Batch No: \_\_\_\_\_

324069 x 12 En 06/05/10

2.0 HAAS1 HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1

Program Batch No. 26973 Double check by: SD

1-Machine Step No 1 per Folio FA051 and inspect per attached Dimension Sheets 2-Machine Step No 2 per

Folio FA051 and inspect per attached Dimension Sheets

3-Machine Step No 3 per Folio FA051 and inspect per attached Dimension Sheets

4-Deburr and remove all machining marks

5-Tumble to remove sharp edges.

3.6/En 06/05/11

12

3.0 MILLING CONV. CONVENTIONAL MILLING MACHINE



Comment: CONVENTIONAL MILLING MACHINE

Machine keyway as per dwg D2571 & D2572

3.6/En 06/05/16

12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☐ No ☒ DQA:   *PD*   Date:   06/05/19  

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 5/4/2006 10:46:25 AM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SADDLE FITTING, FWD (OUTBOARD/INBOARD)

Job Number: 26973

Part Number: D2572

Job Number:



Seq. #:

Machine Or Operation:

Description :

4.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

3.6 Ep 06/05/16 12

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

MS 06/05/17 12

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

SAD 06-05-17 (12)

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

9.m 06-05-18 (12)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

AR 06/05/18 (12)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST479

AR 06/05/18 12

10.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

06/05/18 (12)

Job Completion



U 06/05/19

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

<b>DART AEROSPACE LTD</b>	<b>Work Order:</b>	26973
<b>Description:</b> Saddle, Fwd Inboard	<b>Part Number:</b>	D2572
<b>Inspection Dwg:</b> D2572 Rev. E		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2572 Rev. E and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	0.438	0.443	DT8682	0.441	0.441	0.441	0.441		
B	1.745	1.755		1.745	1.746	1.746	1.748		
C	3.495	3.505		3.496	3.498	3.497	3.495		
D	1.745	1.755		1.745	1.746	1.746	1.748		
E	7.990	8.010		8.000	8.000	8.000	8.000		
F	0.490	0.510		0.499	0.499	0.496	0.500		
G	0.257	0.262	DT8683	0.259	0.259	0.259	0.259		
H	0.375	0.380	DT8684	0.377	0.377	0.377	0.372		
I	0.490	0.510		0.491	0.490	0.492	0.498		
J	1.174	1.184		1.177	1.177	1.175	1.178		
K	0.558	0.578		0.564	0.564	0.564	0.563		
L	1.174	1.184		1.177	1.177	1.175	1.178		
M	1.490	1.500		1.492	1.494	1.493	1.497		
N	2.495	2.505		2.496	2.496	2.495	2.496		
O	3.869	3.879		3.872	3.871	3.872	3.872		
P	0.115	0.135		0.123	0.122	0.123	0.124		
Q	0.115	0.135		0.135	0.135	0.135	0.135		
R	0.240	0.260		0.248	0.247	0.249	0.249		
S	0.115	0.135		0.127	0.122	0.124	0.123		
T	0.178	0.198		0.188	0.188	0.188	0.188		
U	2.940	2.980		2.960	2.960	2.960	2.960		
V	0.230	0.250		0.242	0.242	0.242	0.240		
W	0.115	0.135		0.127	0.125	0.120	0.127		
X	0.307	0.312		0.311	0.311	0.311	0.309		
Y	0.760	0.765		0.765	0.765	0.765	0.765		
Z	0.352	0.372		0.365	0.362	0.360	0.361		
AA	0.470	0.530		0.500	0.500	0.500	0.500		
AB	0.615	0.635		0.623	0.620	0.623	0.620		
AC	0.053	0.073		0.063	0.063	0.063	0.063		
AD	0.240	0.260		0.247	0.246	0.242	0.243		
AE	1.375	1.395		1.379	1.382	1.379	1.386		
AF	0.115	0.135		0.135	0.135	0.135	0.135		
AG	0.240	0.280		0.260	0.260	0.260	0.260		
AH	0.240	0.260		0.253	0.250	0.251	0.247		
AI	2.000	2.020		N/A	N/A	N/A	N/A		
AJ	0.023	0.043		0.033	0.030	0.030	0.030		
Accept/Reject									

Measured by:	MEP
Date:	06/05/14

Audited by:	MB
Date:	06/05/14

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	

<b>DART AEROSPACE LTD</b>	<b>Work Order:</b> 26973
<b>Description:</b> Saddle, Fwd Inboard	<b>Part Number:</b> D2572
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B	1.745	1.755		1.745	1.746	1.748	1.741		
C	3.495	3.505		3.497	3.498	3.497	3.497		
D	1.745	1.755		1.745	1.746	1.748	1.746		
E	7.990	8.010		8.004	8.004	8.003	8.003		
F	0.490	0.510		0.494	0.497	0.498	0.493		
G	0.257	0.262	DT8683	0.260	0.260	0.260	0.260		
H	0.375	0.380	DT8684	0.377	0.377	0.377	0.377		
I	0.490	0.510		0.495	0.501	0.495	0.498		
J	1.174	1.184		1.177	1.176	1.175	1.175		
K	0.558	0.578		0.565	0.566	0.566	0.565		
L	1.174	1.184		1.177	1.176	1.175	1.175		
M	1.490	1.500		1.496	1.492	1.495	1.493		
N	2.495	2.505		2.497	2.496	2.497	2.497		
O	3.869	3.879		3.874	3.872	3.870	3.872		
P	0.115	0.135		0.126	0.123	0.124	0.124		
Q	0.115	0.135		0.135	0.135	0.135	0.135		
R	0.240	0.260		0.250	0.249	0.249	0.251		
S	0.115	0.135		0.124	0.122	0.122	0.123		
T	0.178	0.198		0.188	0.188	0.188	0.188		
U	2.940	2.980		2.960	2.960	2.960	2.960		
V	0.230	0.250		0.240	0.247	0.239	0.236		
W	0.115	0.135		0.117	0.119	0.120	0.117		
X	0.307	0.312		0.310	0.310	0.311	0.311		
Y	0.760	0.765		0.765	0.765	0.765	0.765		
Z	0.352	0.372		0.361	0.365	0.368	0.370		
AA	0.470	0.530		0.500	0.500	0.500	0.500		
AB	0.615	0.635		0.623	0.622	0.620	0.621		
AC	0.053	0.073		0.063	0.063	0.063	0.063		
AD	0.240	0.260		0.241	0.242	0.244	0.246		
AE	1.375	1.395		1.388	1.384	1.387	1.386		
AF	0.115	0.135		0.135	0.135	0.135	0.135		
AG	0.240	0.280		0.260	0.260	0.260	0.260		
AH	0.240	0.260		0.246	0.247	0.248	0.246		
AI	2.000	2.020		N/A	N/A	N/A	N/A		
AJ	0.023	0.043		0.030	0.030	0.030	0.030		
Accept/Reject									

Measured by:	ED
Date:	06/05/15

Audited by:	MS
Date:	06/05/17

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
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E	7.990	8.010		8.003	8.003	8.002	8.002		
F	0.490	0.510		0.494	0.500	0.500	0.498		
G	0.257	0.262	DT8683	0.257	0.257	0.257	0.257		
H	0.375	0.380	DT8684	0.377	0.377	0.377	0.377		
I	0.490	0.510		0.501	0.499	0.498	0.497		
J	1.174	1.184		1.175	1.180	1.180	1.180		
K	0.558	0.578		0.566	0.568	0.568	0.567		
L	1.174	1.184		1.175	1.180	1.180	1.180		
M	1.490	1.500		1.493	1.497	1.497	1.497		
N	2.495	2.505		2.495	2.500	2.501	2.501		
O	3.869	3.879		3.873	3.873	3.872	3.871		
P	0.115	0.135		0.124	0.120	0.121	0.120		
Q	0.115	0.135		0.135	0.135	0.135	0.135		
R	0.240	0.260		0.250	0.246	0.245	0.244		
S	0.115	0.135		0.122	0.123	0.124	0.126		
T	0.178	0.198		0.188	0.188	0.188	0.188		
U	2.940	2.980		2.960	2.960	2.960	2.960		
V	0.230	0.250		0.239	0.244	0.244	0.244		
W	0.115	0.135		0.117	0.124	0.125	0.124		
X	0.307	0.312		0.310	0.310	0.311	0.310		
Y	0.760	0.765		0.765	0.765	0.765	0.765		
Z	0.352	0.372		0.359	0.360	0.361	0.365		
AA	0.470	0.530		0.500	0.500	0.500	0.500		
AB	0.615	0.635		0.624	0.622	0.622	0.623		
AC	0.053	0.073		0.063	0.063	0.063	0.063		
AD	0.240	0.260		0.243	0.244	0.241	0.244		
AE	1.375	1.395		1.385	1.386	1.386	1.386		
AF	0.115	0.135		0.135	0.135	0.135	0.135		
AG	0.240	0.280		0.260	0.260	0.260	0.260		
AH	0.240	0.260		0.247	0.251	0.250	0.252		
AI	2.000	2.020		N/A	N/A	N/A	N/A		
AJ	0.023	0.043		0.030	0.030	0.030	0.030		
Accept/Reject									

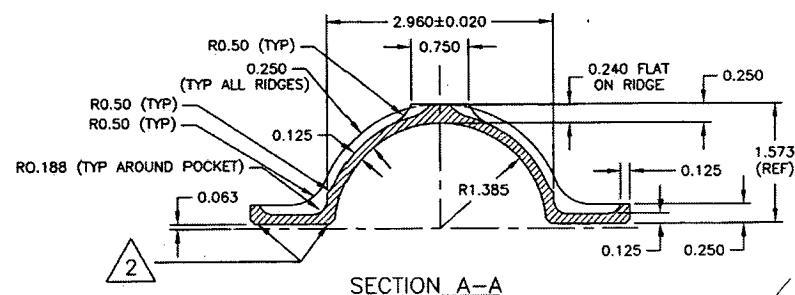
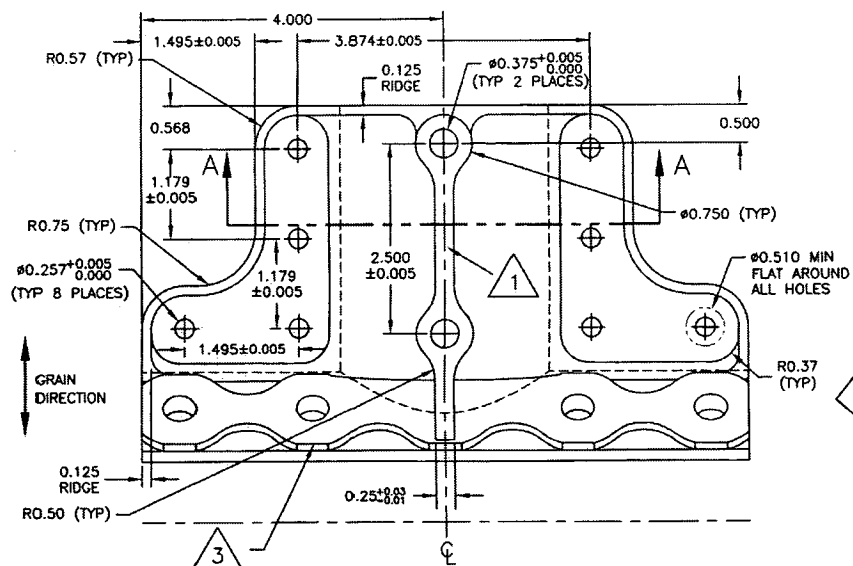
Measured by:	EP/ J.G.
Date:	06/05/16

Audited by:	MR
Date:	06/05/17

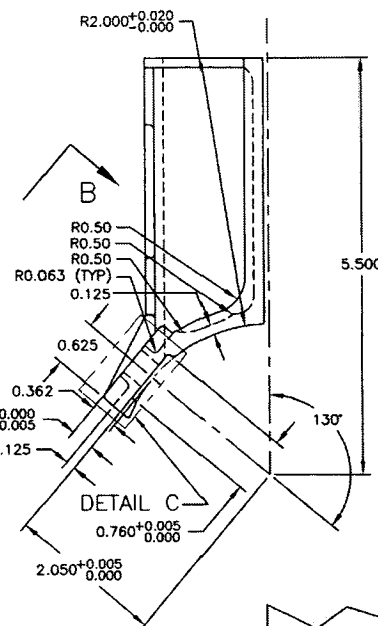
Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	

RELEASED

05.12.06



SECTION A-A



0.438±0.005  
(TYP 4 PLACES)

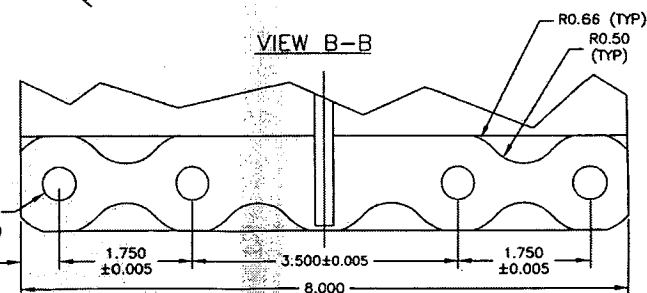
0.060  
R0.025 (TYP)  
4 (TYP)

## NOTES

MATERIAL: 7075-T7351 (QQ-A-250/12)  
(REF DART SPEC. D6102-003)  
FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1  
POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER  
DART QSI 005 4.3  
BREAK ALL SHARP EDGES 0.010 TO 0.020  
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

- 1 ENGRAVE PART AND BATCH NUMBER IN THIS AREA TO MAX DEPTH OF 0.010  
2 CHAMFER 0.063" x 45° AROUND THIS SURFACE (TYPICAL 2 PLACES)  
3 CHAMFER 0.063 x 45° ALL AROUND  
4 CHAMFER 0.033 x 45° (SEE DETAIL C) E

VIEW B-B



E	05.07.13	ADD CHAMFER ON RIDGE NOTE 4
D	02.09.06	ADD RIDGES; TIGHTEN TOLERANCES
C	99.10.22	INCOMP. DEO 9123/9079/9102 ADD DIMENSIONS PER TSR A1177
B	96.12.02	ADD GRAIN DIR., 0.438 WAS 0.425
A	96.09.16	NEW ISSUE

DESIGN	DS	DRAWN BY	PH	<b>DART</b>	DART AEROSPACE LTD.
CHECKED	#	APPROVED	#	DRAWING NO.	REV. E
DATE	05.07.13	TITLE	INNER FWD SADDLE	D2572	SHEET 1 OF 1
		SCALE	2:3		

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DETAIL C  
SCALE 2:1

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